

WHAT IS CLAIMED IS

1. An electroplating method, characterized in that a plating target article disposed so as to be in contact with plating bath is set as a cathode while a metal member disposed so as to be in contact with the plating bath is set as an anode, and a voltage is applied between the cathode and the anode while vibrational flow is induced by vibrating vibrational vanes which are fixed in one-stage or multi-stage style to a vibrating rod vibrating in the plating bath interlockingly with vibration generating means, wherein plating current flowing from the anode through the plating bath to the cathode is pulsed and alternately set to one of a first state where the plating current keeps a first value I1 for a first time T1 and a second state where the plating current keeps a second value I2 having the same polarity as the first value I1 for a second time T2, the first value I1 being five or more times larger than the second value I2, and the first time T1 being three or more times longer than the second time T2.

2. The electroplating method as claimed in claim 1, wherein the first value I1 is 6 to 25 times as large as the second value I2, and the first time T1 is 4 to 25 times as long as the second time T2.

3. The electroplating method as claimed in claim 1, wherein the first value t_1 is set to 0.01 to 300 seconds.

4. The electroplating method as claimed in claim 1, wherein the vibrational vanes are vibrated at an amplitude of 0.05 to 10.0mm and a vibration frequency of 200 to 1500 revolutions per minute.

5. The electroplating method as claimed in claim 1, wherein the vibrational vanes are vibrated so that the vibrational flow of the plating bath has a three-dimensional flow rate of 150mm/second or more.

6. The electroplating method as claimed in claim 1, wherein the
30 vibration generating means vibrates at 10 to 500 Hz.

11. The electroplating method as claimed in claim 10, wherein the width of each of the plating target articles is equal to 5mm or less.